

Work Order ID 86931

86931

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July-09-12 2:50:28 PM

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing
 Start Date: 7/09/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2611	Rev C								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 17389 Purchase part as per Dwg D2611 Possible supplier:
 McMasterP/N: 63215K34 Material release note required

CL 12/10 7/10 (10)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure certificate of conformity is attached

PJ 7/11 (10)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

DAS 16 9-89 12/13/13

CC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86931

July-09-12 2:50:28 PM

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 7/09/12 **Start Qty:** 10.00 ***10***

Required Date: 8/10/12 **Req'd Qty:** 10.00 ***10***

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Identify as per dwg & Stock	Location: <u>ST 12</u>	0.00
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130

Packaging	Memo	0.00
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Packaging

140	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

140

QC	Memo	0.00
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Quality Control

10x _____ Sp
12-7-16

12/17/18 AD

MLJ 12/07/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 86931

Parent Item: D2611

Parent Item Name: Bearing

Start Date: 7/09/12

Required Date: 8/10/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B99.06.23Re-formatDM
Change to SS; Change Supplier- Rev.C 07.03.14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K34 Bearing		Purchased	No				Each	0.0000		10		08/27/11	⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

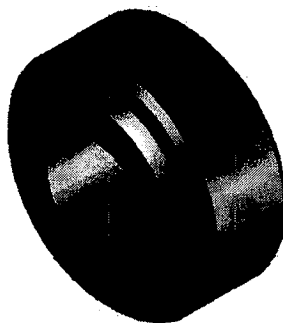
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

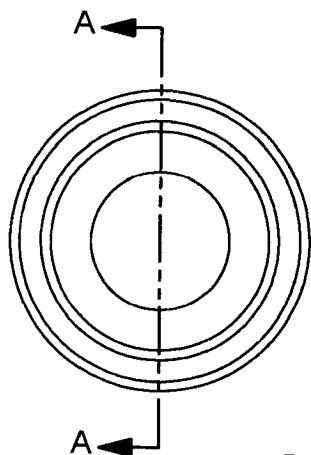


DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20		TITLE BEARING	
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS; CHANGE SUPPLIER	

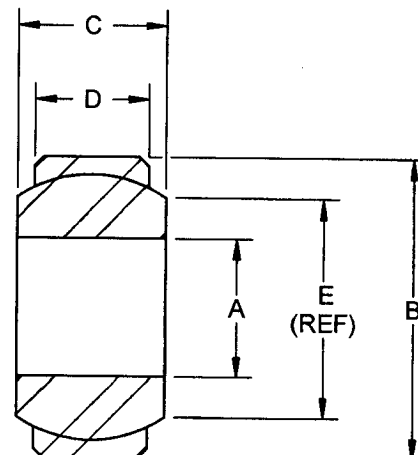
SPECIFICATION CONTROL DRAWING



RELEASED
06.11.17



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *80931 M25*
12/04/10



SECTION A-A



A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17389**

Purchase Order Date 7/10/12

PO Print Date 7/10/12

Page Number 2 of 3

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Requisition Nbr	
Vendor Fax	330 995 9600	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

4	92196A451 SOCKET HEAD CAP SACREW	7/17/12	1.00	FedEx PI collect	\$5.2700	\$5.27
		Yes	Each			

Deliver To: ALEX

5	1931T47 BUTCHER CORD	7/17/12	6.00	FedEx PI collect	\$11.8800	\$71.28
		Yes	Each			

Deliver To: MAT.M

6	2047A67 DIAL INDICATOR	7/17/12	2.00	FedEx PI collect	\$179.0000	\$358.00
		Yes	Each			

Deliver To: CNC

7	63215K34 Bearing	7/17/12	10.00	FedEx PI collect	\$17.2400	\$172.40
		Yes	Each			

Special Inst: AS PER DWG D2611 REV. C
B86931
MCMaster P/N: 63215K34

8	92311A599 SET SCREW	7/17/12	300.00	FedEx PI collect	\$0.2248	\$67.44
		Yes	Each			

Special Inst: AS PER DWG D2712 REV. B
B86911
MCMaster P/N: 92311A599

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr: 4

Change Date: 7/10/12

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO17389

McMaster-Carr Number
6940421-02

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07/10/2012

A1

Line	Description	Ordered	Shipped	
6	2047A67 Brown & Sharpe Bestest Dial Indicator, 0-.030", 0.0005" Graduations, 1-1/2" Dial Diameter, Black Face	2 Each	2	1 - 130
	Unit Price: \$179.00			
	Extended Price: \$358.00			
7	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	10 Each	10	3 - 482
	Unit Price: \$17.24			
	Extended Price: \$172.40			

Shipped separately from our Chicago warehouse on 07/10

3	14065T5 Optional Diamond Indenter for, Portable Dial Hardness Tester	1 Each	1	
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Expected to ship

1	14065T999 1/8" Carbide Ball Indenter for, Portable Dial Hardness Tester, Scales E, H, K	1 Each	1 to ship by 07/24
2	14065T999 1/16" Carbide Ball Indenter for, Portable Dial Hardness Tester, Scales B, F, G	1 Each	1 to ship by 07/24

Charges for this shipment

Merchandise Amount:	\$667.31
Sales Tax:	\$33.36
Total:	\$700.67